

## **PATENT SPECIFICATION**

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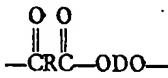
(54) SOFT THERMOPLASTIC SEGMENTED COPOLYESTERS  
SUITABLE FOR USE AS PRESSURE SENSITIVE ADHESIVES

(71) We, E. I. DU PONT DE  
NEMOURS & COMPANY, a corporation  
organised and existing under the laws of the  
State of Delaware, United States of America,  
of Wilmington, Delaware, United States of  
America, do hereby declare the invention, for  
which we pray that a patent may be granted  
to us, and the method by which it is to be  
performed, to be particularly described in and  
10 by the following statement:—

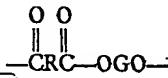
This invention relates to soft thermoplastic, segmented copolyester elastomers and to their use in pressure sensitive adhesives.

Segmented copolyester elastomers are not new. U.S. Patent Specification No. 3,023,192 discloses segmented copolymers containing about 25 to 65 percent by weight of short chain ester units preferably derived from an aliphatic glycol and an aromatic dicarboxylic acid, and about 35 to 75 percent by weight of long chain ester units preferably derived from a high molecular weight polyether glycol and an aromatic dicarboxylic acid which are useful for the preparation of spandex-type fibers.

25 Belgian Patent Specification No. 777,023  
teaches thermoplastic compositions containing  
(A) 1 to 99 percent by weight of thermoplastic  
segmented copolyester elastomer consisting  
essentially of a multiplicity of recurring short  
30 chain ester units and long chain ester units  
joined through ester linkages, said short chain  
ester units amounting to 15 to 75 percent by  
weight of said copolyester and being of the  
formula



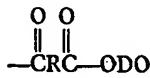
and said long chain ester units amounting to 25 to 85 percent by weight of said copolyester and being of the formula



wherein R is the divalent aromatic radical remaining after removal of the carboxyl groups from an aromatic dicarboxylic acid having a molecular weight of less than 350, D is the divalent radical remaining after removal of the hydroxyl groups from an organic diol having a molecular weight of less than 250, and G is the divalent radical remaining after removal of the terminal hydroxyl groups from a long chain glycol having an average molecular weight of 350 to 6000, said copolyester having a melt index of less than 150 and a melting point of at least 125°C., and (B) 1 to 99 percent by weight of a low molecular weight thermoplastic resin which forms compatible mixtures with the segmented copolyester, is thermally stable at 150°C., and has a melt viscosity of less than 10,000 centipoises at 200°C.

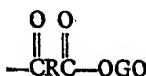
Although the above thermoplastic compositions have good bond strength as hot melt adhesives, they do not make particularly good pressure sensitive adhesives. In order to provide good pressure sensitive adhesive properties, it is necessary that the adhesive remain tacky on its surface for an extended period of time. The pressure sensitive adhesive compositions exemplified in Belgian Patent Specification No. 777,023 had to be used immediately because they lacked this quality.

The present invention provides soft thermoplastic segmented copolyester elastomers which are useful in preparing superior pressure sensitive adhesives and which have a melt index of less than 30 and a melting point of 90° to 132°C and consist essentially of 15 to 50, preferably 15 to less than 30, percent by weight of recurring short chain ester units of the formula:



joined through ester linkages to 50 to 85, preferably more than 70 to 85 percent by weight

of long chain ester units of the formula:



wherein R represents the divalent aromatic groups remaining after removal of the carboxyl groups from a mixture of aromatic dicarboxylic acids (as hereinafter defined) of molecular weight less than 350 and containing 55 to 95 percent by weight of terephthalic acid, D represents the divalent group remaining after removal of the hydroxyl groups from butanediol, and G represents the divalent group remaining after removal of the terminal hydroxyl groups from a polytetramethylene ether glycol having an average molecular weight of 1500 to 3500.

The segmented copolymers of the invention provide superior pressure sensitive adhesives when used in compositions which comprise, based on the total thermoplastic components, (A) to 99 percent by weight of the segmented copolyester and (B) 1 to 99 percent by weight of a low molecular weight thermoplastic resin which forms compatible mixtures with the segmented copolyester, is thermally stable at 150°C., and has a melt viscosity of less than 10,000 centipoises at 200°C.

The soft thermoplastic segmented copolyester elastomers of this invention consist essentially of 15 to 50 percent recurring short chain ester units and 50 to 85 percent long chain ester units joined through ester linkages. The term "consisting essentially of" as used herein, is meant to include in the copolymers only those unspecified polymer units which do not materially affect the basic and essential characteristics of the copolymers of this invention. In other words, this term excludes unspecified polymeric units in amounts which prevent the advantages of the copolymers of this invention from being realized. The term "short chain ester units", as applied to units in a polyester chain, refers to the reaction of butanediol (BDO) with the aromatic dicarboxylic acids. These units are also referred to herein as "hard segments". The term "long chain ester units", as applied to units in a polymer chain, refers to the reaction products of polytetramethylene ether glycol (PTMEG) with the aromatic dicarboxylic acids. These units are also referred to herein as "soft segments". Preferably, the copolyester consists essentially of 15 to less than 30 percent hard segments and more than 70 to 85 percent soft segments.

The weight percent of long chain ester (LCE) units specified herein is calculated in accordance with the following equation in which both the numerator and denominator are expressed in grams.

$$\frac{\text{Wt. \% LCE}}{\text{Theoretical Polymer Yield}} = \frac{\text{A} + \text{B} - \text{C}}{\text{A} + \text{B} - \text{C}}$$

A = (Moles of PTMEG) × (Mole Wt. of PTMEG)  
 B = (Total Moles of Aromatic Dicarboxylic Acid Mixture) × (Mole Wt. of Aromatic Dicarboxylic Acid Mixture) 65  
 C = (Moles H<sub>2</sub>O) × (Mole Wt. of H<sub>2</sub>O)

In this equation the moles of aromatic dicarboxylic acid will be the same as the moles of PTMEG and the moles of water will be twice that of PTMEG. The mole weight of the aromatic dicarboxylic acid mixture should be a weighted average reflecting the composition of the mixture. The theoretical polymer yield will be the grams of ingredients put into the reaction minus the grams of by-products and excess ingredients distilled off.

The weight percent of short chain ester (SCE) units is defined in an analogous manner:

$$\frac{\text{Wt. \% SCE}}{\text{Theoretical Polymer Yield}} = \frac{\text{D} + \text{E} - \text{F}}{\text{D} + \text{E} - \text{F}}$$

D = (Moles of BDO) × (Mole Wt. of BDO)  
 E = (Total Moles of Aromatic Dicarboxylic Acid Mixture) × (Mole Wt. of Aromatic Dicarboxylic Acid Mixture) 85  
 F = (Moles H<sub>2</sub>O) × (Mole Wt. of H<sub>2</sub>O)

Here the moles of butanediol do not include any stoichiometric excess.

The copolymers of this invention are prepared by polymerizing with each other (a) mixture of aromatic dicarboxylic acids containing 55 to 95 percent by weight of terephthalic acid, (b) polytetramethylene ether glycol, and (c) butanediol. By the term "aromatic dicarboxylic acid" is meant a dicarboxylic acid in which each carboxyl group is attached to a carbon atom in an isolated or fused benzene ring or a ring which is itself fused to a benzene ring. The term "dicarboxylic acid", as used herein, is intended to include the equivalents of dicarboxylic acids, that is, their esters or ester-forming derivatives such as acid chlorides and anhydrides, or other derivatives which behave substantially like dicarboxylic acids in a polymerization reaction with a glycol.

The aromatic dicarboxylic acid monomers used in preparing the segmented copolymers have a molecular weight of less than 350. This molecular weight requirement pertains to the acid itself and not to its ester or ester-forming derivative. Thus, the ester of a dicarboxylic acid having a molecular weight greater than 350 can be used provided the acid itself has a molecular weight below 350.

The aromatic dicarboxylic acids used with

terephthalic acid in preparing the segmented copolymers of this invention can contain any substituent group or combinations thereof which do not interfere with the polymerization reaction. Representative aromatic dicarboxylic acids include isophthalic acid, phthalic acid, bisbenzoic acid, substituted dicarboxy compounds with benzene nuclei such as bis(p-carboxyphenyl) methane, p-oxy(p-carboxyphenyl) benzoic acid, ethylene-bis(p-oxybenzoic acid), ethylene-bis(p-benzoic acid), tetramethylene-bis(p-oxybenzoic acid), 1,5-naphthalene dicarboxylic acid, 2,6-naphthalene dicarboxylic acid, 2,7-naphthalene dicarboxylic acid, phenanthrene dicarboxylic acid, anthracene dicarboxylic acid, 4,4'-sulfonyl dibenzoic acid and indene dicarboxylic acid, as well as ring substituted derivatives thereof such as C<sub>1</sub>-C<sub>10</sub> alkyl, halo, alkoxy or aryl derivatives. Hydroxy acids such as p-(β-hydroxyethoxy) benzoic acid can also be used provided an aromatic dicarboxylic acid is also present. The present aromatic dicarboxylic acids for use in combination with terephthalic acid in the preparation of the segmented copolymers are the other aromatic diacids of 8 to 16 carbon atoms, particularly phenylene dicarboxylic acids such as phthalic and isophthalic acids. The most preferred acids are mixtures of terephthalic and isophthalic acids. Preferably, the mixture of aromatic dicarboxylic acids contains 60 to 75 percent terephthalic acid.

Butanediol is used in the preparation of the hard segments of the copolymers of this invention. The term "butanediol", as used herein, should be construed to include equivalent ester-forming derivatives such as tetrahydrofuran or butanediacetate. The polytetramethylene ether glycols used to prepare the soft segments of these copolymers must have molecular weight of 1500 to 3500, and preferably 2000 to 3000.

The relative molecular weight of the segmented copolymer is expressed herein in terms of melt index, which is an empirical measurement of inverse melt viscosity. The segmented copolymer should have a melt index of less than 30 in order to provide compositions having superior pressure sensitive properties. The melt indices specified herein are determined by the American Society for Testing and Materials (herein abbreviated "ASTM") test method D 1238—65T using Condition E at 190°C. with a 2160 gram load. The segmented copolymer should have a melting point of 90° to 132°C.

The required melting point of the segmented copolymer is obtained by providing the polyester with crystallizable short chain ester pigments. Crystallinity in the short chain ester segments is increased by the use of more linear and symmetrical aromatic diacid. By "linear" aromatic diacid is meant a diacid in which each of the bonds between the carboxyl carbons and their adjacent carbons fall on a straight line drawn from one carboxyl carbon to the other. By "symmetrical" aromatic diacid is meant a diacid which is symmetrical with respect to a center line drawn from one carboxyl carbon to the other. For example, repeating ester units such as tetramethylene terephthalate give an especially high melting short chain ester segment. On the other hand, when a non-linear and unsymmetrical aromatic diacid, such as isophthalic acid, is added to crystallizable short chain ester segments, their melting point is depressed. Small amounts of isophthalic acid are, however, very useful for controlling the melting point and improving the compatibility of segmented copolymers with low molecular weight thermoplastic resins.

The melting points specified herein are determined by thermomechanical analysis. The melting point is determined by measuring penetration of a penetrometer type probe into a polymer sample at 10 grams load with the temperature programmed at 5°C./min. The details of this method are described in many publications, for example, in Du Pont Technical Literature for Model 941 Thermomechanical Analyzer, Du Pont Co., Wilmington, Delaware, October 1, 1968.

The copolyester elastomers of this invention can be made by conventional condensation polymerization procedures, as for example, in bulk or in a solvent medium which dissolves one or more of the monomers. They are conveniently prepared by a conventional ester interchange reaction. A preferred procedure involves heating a mixture of the dimethyl esters of terephthalic and isophthalic acids, with polytetramethylene ether glycol and an excess of butanediol in the presence of a catalyst at 150 to 260°C., followed by distilling off the methanol formed by the interchange. Heating is continued until methanol evolution is complete. Depending on the temperature, catalyst and diol excess, this polymerization is complete within a few minutes to a few hours. This procedure results in the preparation of a low molecular weight prepolymer which can be converted to the high molecular weight segmented copolymer of this invention.

These prepolymers can also be prepared by a number of alternative esterification or ester interchange processes. For example, the polytetramethylene ether glycol can be reacted with the short chain ester copolymer in the presence of catalyst until randomization occurs. The short chain ester copolymer can be prepared by ester interchange from either the dimethyl esters and butanediol, as above, or from the free acids with the diol acetates. Alternatively, the short chain ester copolymer can be prepared by direct esterification from appropriate diacids, anhydrides or acid chlorides with butanediol or by other processes

such as reaction of the diacids with cyclic esters or carbonates. Obviously the prepolymer can also be prepared by carrying out these processes in the presence of polytetramethylene ether glycol.

The resulting prepolymer is then converted to the high molecular weight segmented copolyester elastomer or distillation of the excess of butanediol. Best results are usually obtained if this final distillation is carried out at less than 1 mm. pressure and 240—260°C. for less than 2 hours in the presence of an antioxidant such as sym-di-beta-naphthyl-p-phenylenediamine or 1,3,5-trimethyl-2,4,6-tris[3,5 - tertiary - butyl - 4 - hydroxy - benzyl] benzene.

Most practical polymerization techniques rely upon ester interchange to complete the polymerization reaction. In order to avoid excessive hold times at higher temperatures with possible irreversible thermal degradation, it is advantageous to employ a catalyst for the ester interchange reaction. While a wide variety of catalysts can be used, organic titanates such as tetrabutyl titanate, used alone or in combination with magnesium or zinc acetates, are preferred. Complex titanates, such as

$$\text{Mg}[\text{HTi(OR)}_3]_2$$

derived from alkali or alkaline earth metal alkoxides and titanate esters are also very effective. Inorganic titanates such as lanthanum titanate, calcium acetate/antimony trioxide mixtures and lithium and magnesium alkoxides are representative of other catalysts which can be used.

While these condensation polymerizations are generally run in the melt without added solvent, it is sometimes advantageous to run them in the presence of inert solvent in order to facilitate removal of volatile products at lower than usual temperatures. This technique is especially valuable during prepolymer preparation, for example, by direct esterification. Also, butanediol, for example, in terphenyl, is conveniently removed during high polymerization by azeotropic distillation.

The processes described above can be run both by batch and continuous methods. The preferred method for continuous polymerization; namely, ester interchange with a prepolymer, is a well established commercial process. In addition to the novel segmented copolymers, the superior pressure sensitive compositions of this invention also contain one or more low molecular weight thermoplastic resins which form compatible mixtures with the segmented copolyester, are thermally stable at 150°C., and have melt viscosities of less than 10,000 centipoises at 200°C. The term "thermoplastic resin", as used throughout the specification and claims, is intended to include heat softenable resins, both natural and synthetic, as well as waxy types of materials.

By the term "compatible" it is meant that there is no separation into distinct layers between the segmented copolyester and the low molecular weight resin or resins at the copolyester melt temperature. In some cases this compatibility is achieved in multi-component blends even though one of the low molecular weight thermoplastic resin components may not be compatible with the segmented copolyester elastomer alone. By the phrase "thermally stable", it is meant that there is no significant permanent alteration in the properties of the resin after heating at the specified temperature for one hour in the presence of air. The melt viscosities specified herein are measured with a Brookfield viscometer by ASTM test method D 1824—66 at elevated temperatures as indicated.

Suitable low molecular weight thermoplastic resins include hydrocarbon resins, bituminous asphalts, coal tar pitches, rosins, rosin based alkyd resins, phenolic resins, chlorinated aliphatic hydrocarbon waxes, chlorinated polynuclear aromatic hydrocarbons, and mixtures thereof.

The term "hydrocarbon resins" refers to hydrocarbon polymers derived from coke-oven gas, coal-tar fractions, cracked and deeply cracked petroleum stocks, essentially pure hydrocarbon feeds, and turpenines. Typical hydrocarbon resins include coumarone-indene resins, petroleum resins, vinyl aromatic polymers, cyclopentadiene resins, and terpene resins. These resins are fully described in the Kirk-Othmer "Encyclopedia of Chemical Technology", Second Edition, 1966, Interscience Publishers, New York, Volume II, Pages 242 to 255.

The term "coumarone-indene resins" refers to hydrocarbon resins obtained by polymerization of the resin formers recovered from coke-oven gas and in the distillation of coal tar and derivatives thereof such as phenol-modified coumarone-indene resins. These resins are fully described in the Kirk-Othmer Encyclopedia, supra, Volume 11, pages 243 to 247.

The term "petroleum resins" refers to hydrocarbon resins obtained by the catalytic polymerization of deeply cracked petroleum stocks. These petroleum stocks generally contain mixtures of resin formers such as styrene, methyl styrene, vinyl toluene, indene, methyl indene, butadiene, isoprene, piperylene and pentylenes. These resins are fully described in the Kirk-Othmer Encyclopedia, supra, Volume 11, pages 248 to 250. The so-called "polyalkylaromatic resins" fall into this classification.

The term "vinyl aromatic polymers" refers to low molecular weight homopolymers of vinyl aromatic monomers such as styrene, vinyl toluene, and alpha-methyl styrene, copolymers of two or more of these monomers with each other, and copolymers containing one or more

of these monomers in combination with other monomers such as butadiene. These polymers are distinguished from petroleum resins in that they are prepared from substantially pure monomer.	the Kirk-Othmer Encyclopedia, supra, Volume 1, pages 851, 865 and 866.	65
The term "cyclopentadiene resins" refers to cyclopentadiene homopolymers and copolymers derived from coal tar fractions or from cracked petroleum streams. These resins are produced by holding a cyclopentadiene-containing stock at elevated temperature for an extended period of time. The temperatures at which it is held determines whether the dimer, trimer, or higher polymer is obtained. These resins are fully described in the Kirk-Othmer Encyclopedia, supra, Volume 11, pages 250 and 251.	The term "phenolic resins" refers to the products resulting from the reaction of phenols with aldehydes. In addition to phenol itself, cresols, xylenols, p-tert.-butylphenol and p-phenylphenol may be used as the phenol component. Formaldehyde is the most common aldehyde, but acetaldehyde and furfuraldehyde may also be used. These resins are fully described in the Kirk-Othmer Encyclopedia, supra, Volume 15, Pages 176 to 207.	70
The term "terpene resins" refers to polymers of terpenes which are hydrocarbons of the general formula $C_{10}H_{16}$ , occurring in most essential oils and oleoresins of plants, and phenol-modified terpene resins. Suitable terpenes include alpha-pinene, beta-pinene, dipentene, limonene, myrcene, bornylene and camphene. These products occur as by-products of coking operations of petroleum refining and of paper manufacture. These resins are fully described in the Kirk-Othmer Encyclopedia, supra, Volume 11, Pages 252 to 254.	The term "chlorinated aliphatic hydrocarbon waxes" refers to those waxes which are commonly called "chlorinated waxes" such as chlorinated paraffin waxes. These waxes typically contain 30—70 percent by weight of chlorine.	75
The term "bituminous asphalts" is intended to include both native asphalts and asphaltites such as "Gilsconite", Glance pitch and Grahamite. A full description of bituminous asphalts can be found in Abraham's "Asphalts and Allied Substances", 6th Edition, Volume 1, Chapter 2, Van Nostrand Co., Inc., particularly Table III on Page 60.	The term "chlorinated polynuclear aromatic hydrocarbons" refers to chlorinated aromatic hydrocarbons containing two or more aromatic rings such as chlorinated biphenyls and terphenyls, and mixtures thereof. These materials typically contain 30 to 70 percent by weight of chlorine.	80
The term "coal tar pitches" refers to the residues obtained by the partial evaporation or distillation of coal tar obtained by removal of gaseous components from bituminous coal. Such pitches include gas-works coal tar pitch, coke-oven coal tar pitch, blast furnace coal tar pitch and producer-gas coal tar pitch. These pitches are fully described in Abraham's "Asphalts and Allied Substances", supra, particularly Table III on Page 61.	The compositions of this invention contain 1 to 99 percent by weight, preferably 5 to 95 percent by weight of thermoplastic segmented copolyester elastomer and 99 to 1 percent by weight, preferably 95 to 5 percent by weight, of low molecular weight thermoplastic resins. More preferably, the composition contains 20 to 60 percent by weight of the elastomer and 80 to 40 percent by weight of the resin.	85
The term "rosins" refers to the resinous materials that occur naturally in the oleoresin of pine trees, as well as derivatives thereof including rosin esters, modified rosins such as fractionated, hydrogenated, dehydrogenated and polymerized rosins and modified rosin esters. These materials are fully described in the Kirk-Othmer Encyclopedia, supra, Volume 17, Pages 475 to 505.	Typically, the compositions of this invention contain more than one low molecular weight thermoplastic resin. For example, low molecular weight vinyl aromatic polymers have been found to lower the melt viscosity of these compositions without substantially lowering the softening point. Since low melt viscosity contributes improved wetting by the composition of the surface of the substrate, which results in better adhesion, many useful compositions will contain some vinyl aromatic polymer. Vinyl aromatic polymers are also useful for increasing the compatibility of other resins with the segmented copolyester elastomer. Coumarone-indene resins of high softening point have been found to give strength to the compositions. Phenol-modified coumarone-indene resins have been found to have the effect of lowering the softening point of the composition. In fact, the effect of phenol-modified coumarone-indene resins on the melting point is so great that the desired melting point is generally achieved by the addition of only a small amount of this resin. Any combination of these desired properties can be achieved by mixing two or more low molecular weight thermoplastic resins with the copolyester elastomer in a proper proportion. The low molecular weight thermoplastic resins also have the effect of lowering the cost of the composition.	90
The term "rosin based alkyl resins" refers to alkyl resins in which all or a portion of the monobasic fatty acid is replaced by rosin (a mixture of diterpene resin acids and non-acidic components). Unmodified alkyl resins are polyester products composed of polyhydric alcohol, polybasic acid and monobasic fatty acid. Rosin based alkyl resins are described in		95
		100
		105
		110
		115
		120
		125

It is sometimes desirable to stabilize the compositions of this invention against heat or radiation by ultra-violet light. This can be done by incorporating stabilizers or anti-oxidants in these compositions. Satisfactory stabilizers comprise phenols and their derivatives, amines and their derivatives, compounds containing both hydroxyl and amine groups, hydroxyazines, oximes, polymeric phenolic esters, and salts of multi-valent metals in which the metal is in its lower valence state.

Representative phenol derivatives useful as stabilizers include hydroquinone, 2,6-di-tertiary - butyl - p - cresol, tetrakis[methylene - 3 - (3',5' - diteriary - butyl - 4' - hydroxyphenyl)propionate]methane, 4,4' - bis(2,6' - diteriary - butylphenol; 1,3,5 - trimethyl - 2,4,6 - tris[3,5 - diteriary - butyl - 4 - hydroxybenzyl]benzene, and 4,4' - butylidene - bis(6 - tertiary - butyl - m - cresol). Various inorganic metal salts or hydroxides can be used as well as organic complexes such as nickel dibutyl dithiocarbamate, manganous salicylate, and copper 3 - phenyl - salicylate.

Typical amine stabilizers include aromatic amines such as N,N' - bis(beta - naphthyl) - p - phenylenediamine, N,N' - bis(1 - methyl - heptyl) - p - phenylene diamine, and either phenyl-beta-naphthyl amine or its reaction products with aldehydes. Mixtures of hindered phenols with esters of thiadipropionic acid, mercaptides and phosphite esters are particularly useful. Additional stabilization to ultra-violet light can be obtained by compounding with various UV absorbers such as substituted benzophenones or benzotriazoles.

The properties of the compositions of this invention can be modified by the incorporation of various conventional inorganic fillers such as wood flour, silicates, silica gel, alumina, clays, chopped fiberglass, titanium dioxide and carbon black. In general, fillers have the effect of increasing the melt viscosity and the modulus or stiffness of the composition at various elongations.

The properties of the compositions of this invention can be further modified by the incorporation of thermally stable thermoplastic polymers of ethylenically unsaturated monomers including homopolymers of vinyl esters such as vinyl acetate, copolymers of these vinyl esters with other vinyl monomers such as ethylene and vinyl chloride, and polymers of alkyl acrylates and methacrylates, or thermally stable condensation polymers such as polyesters and polyamides. For example, the addition of a copolymer of ethylene and vinyl acetate often increases the tackiness of pressure sensitive adhesive compositions of this invention. These modifying polymers typically have melt viscosities above 10,000 centipoises at 200°C. and thus are not low molecular weight thermoplastic resins as defined herein.

These compositions can also be colored by the addition of organic or inorganic pigments or organic dyes where their effect is desired. Suitable inorganic pigments include rutile and anatase titanium dioxides, aluminum powder, cadmium sulfides and sulfo-selenides, lead antimonate, mercury, cadmiums, chromates of nickel, tin and lead, ceramic greens such as chromium, cobalt, titanium and nickel oxides, ceramic blacks such as chromium, cobalt and iron oxides, carbon black and ultramarine blue. Suitable organic pigments include phthalocyanine blues and greens and quinacridones. Suitable dyes include disperse dyes such as Colour Index Disperse Blues 59, 63 and 64. Optical brighteners such as "Uvitex" CF, sold by Ciba Corp., and "Tinopal" AN, sold by Geigy Chemical Corp., may also be incorporated where their effect is desired.

Plasticizers including phthalate esters such as dioctyl phthalate and dicyclohexyl phthalate, aryl phosphates such as tricresyl phosphate, and substituted sulfonamides such as N - cyclohexyl - p - toluene - sulfonamide, may be added for applications where their effect is desired. Flame retardant additives, such as zinc borates, antimony trioxide, tris(2,3-dichloropropyl) phosphate, tris(2,3-dibromopropyl) phosphate and chlorinated waxes, may be added, if desired. Other minor additives such as surfactants or lubricants may also be added.

One of the important advantages of the thermoplastic compositions of this invention is that the copolyester elastomers and the low molecular weight thermoplastic resins are easy to blend together due to the relatively low melt viscosity of these compositions at elevated temperatures as compared to compositions of the prior art having comparable bond strength. The components of the compositions of this invention can be blended by variously well-known procedures such as, for example, blending in molten form, blending in a solvent, or mixing aqueous dispersions of the components. Blending in the melt may be carried out by first melting the segmented copolyester elastomer and then adding low molecular weight thermoplastic resin to the melt, by first melting the low molecular weight thermoplastic resin and then adding segmented copolyester elastomer to the melt, or by first blending the segmented copolyester elastomer and the low molecular weight thermoplastic resin together in finely divided form and then melting the blend, for example, on a hot roller mill or by simultaneously feeding the components to an extruder.

In addition to these blending procedures, it is also possible to take the copolyester from the synthesis step and, while it is still molten, blend solid, premelted, or liquid low molecular weight thermoplastic resin with it. Other ingredients such as antioxidants, fillers, and plasticizers can also be added at this time. This blending process can be carried out with an in-line mixer or with a separate mixing

vessel, and has the advantage that it does not require isolation of the copolyester.

The thermoplastic compositions of this invention can also be blended by dissolving the segmented copolyester and the low molecular weight thermoplastic resin in a solvent. Suitable solvents for preparing these solutions include chlorinated hydrocarbons such as methylene chloride, chloroform, trichloroethylene and solvent mixtures such as mixtures of trichloroethylene and isopropanol.

Aqueous dispersions of the thermoplastic compositions of this invention can be prepared by dissolving the segmented copolyester and the low molecular weight thermoplastic resin together in a suitable water-immiscible organic solvent, emulsifying the organic solvent containing the segmented copolyester and the low molecular weight thermoplastic resin in water, and removing the organic solvent as described in U.S. Patent Specification No. 3,296,172. Dispersions can also be prepared by dissolving the segmented copolyester in a suitable water-immiscible organic solvent, dissolving the low molecular weight thermoplastic resin in a different water-immiscible organic solvent, emulsifying each organic solvent solution in water, removing the organic solvent from each emulsion, thereby forming separate dispersions, and mixing the dispersions together in proper amounts.

Compositions containing 50 percent by weight or more of segmented copolyester elastomer can be used as concentrates for further compounding with the same or other low molecular weight thermoplastic resins and modifiers, as well as being useful as such. Such concentrated compositions have the advantage of being processable with additional components at lower temperatures and shear requirements than the segmented copolyester elastomer itself. For example, a mixture containing an equal weight of segmented copolyester elastomer and low molecular weight, thermoplastic styrene homopolymer is typically blended at a minimum temperature of about 170°C. However, additional low molecular weight thermoplastic resins can be mixed with this concentrate at a minimum blending temperature of about 140°C. Moreover, additional low molecular weight thermoplastic resins which have limited compatibility with the segmented copolyester elastomer alone tend to be more compatible with such concentrates.

The compositions of this invention are useful as pressure sensitive adhesives. These compositions can be applied on the form of a solution, an aqueous dispersion, or in molten form. The method of application does not appreciably affect the performance of the composition.

Conventional application equipment can be used for applying the compositions of this invention in the various forms. For application of solutions or dispersions various known application techniques can be used including brushing, dipping, roll coating wirewound rod application, doctoring and printing. Spraying or curtain coating techniques are also applicable to these forms of the compositions.

The compositions of this invention have sufficient thermal stability to render them suitable for hot melt application with good pot life. Heating to 150 to 200°C. does not appreciably alter the properties of the composition. For application of these compositions in the melt form, dipping, roll coating, calendering, curtain coating, extruding, hot spraying, and other hot melt application techniques can be used.

The compositions of this invention are characterized by an outstanding combination of pressure sensitive adhesive properties. Performance of a pressure sensitive adhesive is gauged by measurement of both peel and shear adhesion to standard substrates. Tack is also an important property. Compositions described herein display 180° peel values as high as 4—5 lbs./in. and 90° quick stick values as high as 3.5—4.0 lbs./in. They have good shear strength (300+ hrs. at RT) and similarly exhibit good high temperature bond strength (as high as 185 min. at 70°C.). Tack levels are high (1—6 inches) as measured by rolling ball tack or by Polyken probe tack measurement (as high as 950 g.). A good balance of all the properties mentioned above can be obtained by proper formulation, or any one property can be specifically enhanced by formulation.

The following Examples serve to illustrate the segmented copolyester elastomers and adhesive compositions of this invention. All parts and percentages are by weight. Tensile properties were determined with compression molded samples using ASTM test method D1708—66.

The test methods used in the pressure sensitive adhesive evaluations are procedures developed by the Specifications and Technical Committee of the Pressure Sensitive Tape Council (PSTC) as published in their manual entitled "Test Methods for Pressure Sensitive Tapes—Fifth Edition" and the Polyken Probe Tack Test. Briefly these tests are as follows:

180° Peel Adhesion Test (PSTC-1)—Peel adhesion is the force required to remove a pressure sensitive tape from a substrate at an angle of 180° at a specified speed. The tape is applied to a standard test panel using a 4.5 pound roller to make the contact. The tape is pulled on an "Instron" machine at the rate of 30 cm./min. and the force is expressed in pounds per inch width of tape.

90° Peel Quick Stick Adhesion Test (PSTC-5)—Quick Stick is that property of a pressure sensitive tape which causes the tape to adhere to a surface instantly, using no external pressure to secure more thorough contact. It is measured as the force resisting peeling of a tape at 90° from a standard sur-

face upon which it has been applied under no other pressure than the weight of the tape itself. The tape is peeled from the standard surface in a 90° configuration at the rate of 30 cm./min.	Tyzor TBT, which is tetrabutyltitanate, sold by E. I. du Pont de Nemours and Company, was added as a 5% solution in butane-diol.	65
5. Rolling Ball Tack Test (PSTC-6)—In this test a 7/16 inch diameter steel ball is rolled down an inclined plane to the pressure sensitive surface and the distance the ball rolls is measured. The shorter the distance, the better the tack.	The reaction kettle is heated to 150°C. at atmospheric pressure at which time the catalyst is charged. The reaction is then heated to 250°C. under a nitrogen atmosphere over a period of 1 hour. Methanol distillation starts almost immediately and is essentially complete in 20 minutes. When the temperature reaches 250°C. a vacuum of 160 mm. is applied and held for 5 minutes, after which the pressure is further reduced to 80 mm. for 5 min., 40 mm. for 5 min., and finally to full vacuum (0.5 mm. of Hg or less) and distillation is continued at full vacuum at 250°C. for 1 hour. The resulting viscous molten product is scraped from the flask in a nitrogen ( $H_2O$ and $O_2$ free) atmosphere and allowed to cool. Samples for physical testing are prepared by compression molding at 175—185°C. followed by rapid cooling in the press. The polymer physical properties are listed in Table I.	70
10. Shear Adhesion Test (PSTC-7)—Shear adhesion is the force required to pull the pressure sensitive tape from a standard flat surface in a direction parallel to the surface to which it has been affixed with a definite pressure. It can be measured in terms of the time required to pull a standard area of tape from the test panel under a standard load. Standard load used was 1000 grams on a 1 in. $\times$ 1 in. tape contact area. Testing was conducted at both room temperature and 70°C. Time to failure was recorded.	75	
15. Polyken Probe Tack Test—A Polyken Probe Tack Tester, Model No. TMI 80-2, was used for this test. This tester is a device for measuring the tackiness of pressure sensitive adhesives, by bringing the flat tip of a probe into contact with the test specimen at a controlled rate, contact pressure, and dwell time, and subsequently breaking the adhesive bond thus formed, also at a controlled rate. The standard probe is a 0.5-cm. diameter, 304 stainless steel rod which is mounted by means of a collet chuck directly on a mechanical force gauge fitted with a dial indicator.	80	
20. In these tests, the highly polished end of the probe was used. A contact pressure of 100 g./cm. <sup>2</sup> , and a dwell time of 1 sec. was also used with the probe and sample being brought into contact and separated at the rate of 1 cm./sec. Further details of this test are available from the Kendall Company or Testing Machines Company.	85	
25. EXAMPLE 1 The following materials are placed in a 3000 ml. resin kettle fitted for distillation:	EXAMPLE 2 (Control) Following the procedure described in Example 1, a thermoplastic segmented copolyester elastomer is prepared from the following materials:	90
30. Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100 1,4-Butanediol (40% Excess)	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100 1,4-Butanediol (40% Excess)	95
35. Dimethyl Terephthalate Dimethyl Isophthalate "Naugard" 445 Tyzor TBT (Tetrabutyltitanate, 5% Solution in BDO)	Dimethyl Terephthalate Dimethyl Isophthalate "Naugard" 445 Tyzor TBT (Tetrabutyltitanate, 5% Solution in BDO)	100
40. 1,4-Butanediol (40% Excess)	1,4-Butanediol (40% Excess)	100
45. The properties of the resulting polymer are described in Table I.	EXAMPLE 3 (Control) Following the procedure detailed in Example 1, a polymer is prepared from the following materials:	105
50. Polytetramethylene Ether Glycol (PTMEG); Number Average Molecular Weight 2100 1,4-Butanediol (BDO) (40% Excess)	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100 1,4-Butanediol (40% Excess)	110
55. Dimethyl Terephthalate (DMT) Dimethyl Isophthalate (DMI) "Naugard" 445 Tyzor TBT (Tetrabutyltitanate, 5% Solution in BDO)	Dimethyl Terephthalate (DMT) Dimethyl Isophthalate (DMI) "Naugard" 445 Tyzor TBT (Tetrabutyltitanate, 5% Solution in BDO)	115
60. 1,4-Butanediol (40% Excess)	1,4-Butanediol (40% Excess)	115

"Naugard" 445 is an antioxidant sold by Naugatuck Chemicals, a division of Uniroyal.

The properties of the resulting polymer are described in Table I.

**EXAMPLE 4**

The following materials are charged to a 20 gallon distillation vessel:

5	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	6300 g.	properties of the resulting polymer are listed in Table I.
10	1,4-Butanediol	1419 g. (50% Excess)	
15	Dimethyl Terephthalate	2097 g.	
20	Dimethyl Isophthalate "Naugard" 445	524 g. 50 g.	
25	Tyzor TBT (Neat)	5.8 g.	

The Tyzor TBT is added last to the still and the temperature programmed over 1 hour to 210°C. at atmospheric pressure under nitrogen. When roughly stoichiometric amounts (865 g.) of methanol are distilled off (2-3 hours), the still contents are transferred to an autoclave for further polymerization. The autoclave is held at 240°C. and the pressure is gradually reduced to 1-2 mm. over a 45-minute period. The reaction mixture is held at 240°C. until excess (473 g.) diol is distilled off (4-5 hours). The reaction mixture is then extruded out of the polymerizer in ribbon form and subsequently ground to coarse particles. The physical properties of the resulting polymer are listed in Table I.

**EXAMPLE 5**

Following the procedure described in Example 4, a thermoplastic copolyester elastomer is prepared from the following materials:

30	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	6300 g.	80
35	1,4-Butanediol	1520 g. (50% Excess)	
40	Dimethyl Terephthalate Dimethyl Isophthalate "Naugard" 445	1937 g. 830 g. 50 g.	
45	Tyzor TBT (Neat)	5.8 g.	

During the distillation 913 g. of methanol and 506 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.

**EXAMPLE 6**

Following the procedure described in Example 4, a thermoplastic copolyester elastomer is prepared from the following materials:

50	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	5880 g.	65
55	1,4-Butanediol	1570 g. (50% Excess)	
60	Dimethyl Terephthalate Dimethyl Isophthalate "Naugard" 445	1867 g. 934 g. 50 g.	
65	Tyzor TBT (Neat)	5.9 g.	

During the distillation 924 g. of methanol and 523 g. of butanediol are removed. The physical

**EXAMPLE 7**

Following the procedure described in Example 4, a thermoplastic copolyester elastomer is prepared from the following materials:

5	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	5880 g.	65
10	1,4-Butanediol	1703 g. (50% Excess)	70
15	Dimethyl Terephthalate Dimethyl Isophthalate "Naugard" 445	1994 g. 997 g. 50 g.	
20	Tyzor TBT (Neat)	6.3 g.	75

During the distillation 987 g. of methanol and 568 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.

**EXAMPLE 8**

Following the procedure described in Example 4, a thermoplastic copolyester elastomer is prepared from the following materials:

5	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	8400 g.	80
10	1,4-Butanediol	3244 g. (50% Excess)	
15	Dimethyl Terephthalate Dimethyl Isophthalate "Naugard" 445	3698 g. 1740 g. 75.0 g.	90
20	Tyzor TBT (Neat)	15.0 g.	

During the distillation 1794 g. of methanol and 1081 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.

**EXAMPLE 9**

Following the procedure described in Example 4, a thermoplastic copolyester elastomer is prepared from the following materials:

5	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	10,500 g.	100
10	1,4-Butanediol	2196 g. (50% Excess)	105
15	Dimethyl Terephthalate Dimethyl Isophthalate "Naugard" 445	2806 g. 1320 g. 75.0 g.	
20	Tyzor TBT (Neat)	15.0 g.	

During the distillation 1362 g. of methanol and 732 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.

**EXAMPLE 10**

Following the procedure described in Example 1, a thermoplastic copolyester elastomer is prepared from the following materials:

5	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	630 g.	115
10			

	1,4-Butanediol	152 g.	During the distillation 92.0 g. of methanol and 52.0 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.	60
5	Dimethyl Terephthalate	(50% Excess) 166 g.		
	Dimethyl Isophthalate	111 g.		
	"Naugard" 445	4.6 g.		
	Tyzor TBT (Neat)	0.58 g.		
10	During the distillation 91.3 g. of methanol and 50.7 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.			
	<b>EXAMPLE 11</b> Following the procedure described in Example 1, a thermoplastic copolyester elastomer is prepared from the following materials:			
15	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	567 g.		
	1,4-Butanediol	(50% Excess) 146 g.		
20	Dimethyl Terephthalate	210 g.		
	Dimethyl Isophthalate	52 g.		
	"Naugard" 445	4.2 g.		
	Tyzor TBT (Neat)	0.55 g.		
25	During the distillation 86.5 g. of methanol and 48.6 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.			
	<b>EXAMPLE 12</b> Following the procedure described in Example 1, a thermoplastic copolyester elastomer is prepared from the following materials:			
30	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	588 g.		
	1,4-Butanediol	(50% Excess) 132 g.		
35	Dimethyl Terephthalate	196 g.		
	Dimethyl Isophthalate	49 g.		
	"Naugard" 445	4.2 g.		
40	Tyzor TBT (Neat)	1.0 g.		
	During the distillation 81.0 g. of methanol and 44.0 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.			
45	<b>EXAMPLE 13</b> Following the procedure described in Example 1, a thermoplastic copolyester elastomer is prepared from the following materials:			
50	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	588 g.		
	1,4-Butanediol	(50% Excess) 157 g.		
55	Dimethyl Terephthalate	187 g.		
	Dimethyl Isophthalate	93.5 g.		
	"Naugard" 445	4.4 g.		
	Tyzor TBT (Neat)	0.9 g.		
	During the distillation 1117 g. of methanol and 620 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.			
	<b>EXAMPLE 14</b> Following the procedure described in Example 1, a thermoplastic copolyester elastomer is prepared from the following materials:			
	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	567 g.		
	1,4-Butanediol	(50% Excess) 146 g.		
	Dimethyl Terephthalate	210 g.		
	Dimethyl Isophthalate	52 g.		
	"Naugard" 445	4.2 g.		
	Tyzor TBT (Neat)	0.8 g.		
	During the distillation 86.0 g. of methanol and 49 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.			
	<b>EXAMPLE 15</b> The following materials are polymerized using a continuous process rather than a batch process as in the previous examples thereby enabling a higher molecular weight polymer to be obtained.			
	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2100	400	Parts	85
	1,4-Butanediol	96.6		
	Dimethyl Terephthalate	123		90
	Dimethyl Isophthalate	52.7		
	Goodrite 3110×104	5.82		
	Tyzor TBT (Neat)	0.58		
	Goodrite 3110×104 is a hindered phenol antioxidant sold by B. F. Goodrich Co. The physical properties are listed in Table I.			
	<b>EXAMPLE 16</b> Following the procedure described in Example 4, a thermoplastic copolyester elastomer is prepared from the following materials:			
	Polytetramethylene Ether Glycol; Number Average Molecular Weight 2900	10,643 g.		
	1,4-Butanediol	1,860 g.		
	Dimethyl Terephthalate	2,369 g.		105
	Dimethyl Isophthalate	1,016 g.		
	"Naugard" 445	71 g.		
	Tyzor TBT (Neat)	14.2 g.		
	During the distillation 1117 g. of methanol and 620 g. of butanediol are removed. The physical properties of the resulting polymer are listed in Table I.			

TABLE I  
Polyester Compositions

Example	Mole Ratios		SCE, %	Tensile Properties		Melt Index (2160 g. 190°C.)	Melting Point (TMA, °C.)
	DMT	DMT+DMI		BDO	Strength (Psi.)	% Elong.	
1	0.57	7.64	44.5	4410	1095	1100	3.84
2 (Control)	0.50	4.13	28.9	3700	1200	680	109
3 (Control)	0.67	2.71	21.8	4220	1175	540	80
4	0.80	3.50	25.7	3920	1300	2450	40
5	0.70	3.75	27.0	4650	1400	2370	132
6	0.67	4.15	29.1	2870	1400	2460	9.2
7	0.67	4.50	30.8	4440	1300	2930	97
8	0.68	6.00	37.2	3990	1000	2320	9.2
9	0.68	3.25	24.3	3800	1200	1210	115
10	0.60	3.75	27.0	2440	1220	676	111
11	0.80	4.00	28.3	5130	1230	1840	4.4
12	0.80	3.50	25.7	5040	1200	2430	3.3
13	0.67	4.15	29.1	4100	1100	2220	4.4
14	0.80	4.00	28.3	4790	1300	3150	119
15	0.70	3.75	27.0	4500	1100	1430	132
16	0.70	3.75 <sup>a</sup>	24.8	4180	1300	1120	106
							95

1. Glycol MW=2100 except, where noted.

2. Glycol MW=2900.

**EXAMPLE 17**  
(Control)

A pressure sensitive adhesive blend is prepared by blending the following materials at 5 175°C. with stirring for approximately 1 hour until homogeneous:

	Blend I	
	Polymer of Example 2	20 g.
10	Piccolastic A-5	20 g.
	Piccolastic A-75	15 g.
	Piccovar L-30	15 g.
	"Aroclor" 5460	25 g.
	"Elvax" 40	5 g.
	"Naugard" 445	0.3 g.

15 Piccolastic A-5 is a low molecular weight styrene homopolymer having a ring and ball softening point of about 5°C. and a melt viscosity of 18 centipoises at 190°C. sold by Pennsylvania Industrial Chemical Corp.  
 20 Piccolastic A-75 is a low molecular weight styrene homopolymer having a ring and ball softening point of about 75°C. sold by Pennsylvania Industrial Chemical Corp. Piccovar L-30 is a polyindene petroleum resin having a softening point of 30°C. sold by Pennsylvania Industrial Chemical Corp. "Aroclor" 5460 is a chlorinated polystyrene sold by Monsanto Co.  
 25 "Elvax" 40 is an ethylene/vinyl acetate copolymer containing 60 percent ethylene and 40 percent vinyl acetate sold by E. I. du Pont de Nemours and Co.  
 Adhesive is applied 1 mil thick to 1-mil  
 30 "Mylar" film at 120°C. and pressure sensitive adhesive properties are determined. The resulting data are given in Table II.  
 35

**EXAMPLE 18**  
(Control)

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared 40 by blending the following materials:

	Polymer of Example 3	25 g.
	Piccolastic A-25	24 g.
	Piccolastic A-75	16.5 g.
45	Piccotex LC	20 g.
	"Elvax" 40	4.5 g.
	"Paraplex" G-62	10 g.
	"Naugard" 445	0.5 g.

50 Piccolastic A-25 is a low molecular weight styrene homopolymer having a ring and ball softening point of about 25°C. sold by Pennsylvania Industrial Chemical Corp. Piccotex LC is a vinyl toluene- $\alpha$ -methyl styrene copolymer sold by Pennsylvania Industrial Chemical Corp. "Paraplex" G-62 is an epoxidized soybean oil plasticizer sold by Rohm and Haas Co. The resulting data are given in Table II.

**EXAMPLE 19**

Following the procedure of Example 17 a pressure sensitive adhesive blend was prepared by blending the following materials: 60

Polymer of Example 4	30 g.
Piccovar L-30	25 g.
Piccotex 75	40 g.
"Elvax" 4260	5 g.
"Naugard" 445	0.5 g. 65

Piccotex 75 is a vinyl toluene copolymer petroleum resin sold by Pennsylvania Industrial Corp. "Elvax" 4260 is an ethylene/vinyl acetate copolymer containing 71 percent ethylene, 28 percent vinyl acetate and 1 percent methacrylic acid sold by E. I. du Pont de Nemours and Company. The resulting data are given in Table II. 70

**EXAMPLE 20**

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials: 75

Polymer of Example 5	30 g.
Piccotex 75	33 g.
Picco XPS-250-40	4 g. 80
Piccovar L-30	33 g.
"Naugard" 445	0.5 g.

Picco XPS-250-40 is a vinyl toluene- $\alpha$ -methyl styrene copolymer sold by Pennsylvania Industrial Chemical Corp. The resulting data are given in Table II. This composition displayed a particularly good balance of pressure sensitive properties. Tack was aggressive and high temperature bond strength was good. 85

**EXAMPLE 21**

Following the procedure of Example 17 a pressure sensitive adhesive blend was prepared by blending the following materials: 90

Polymer of Example 6	28 g.
Piccolastic A-25	25 g. 95
Piccolastic A-50	5 g.
Piccotex LC	32 g.
Plasticizer Mixture (10.0 parts/ 16.5 parts/9.0 parts diiso- octylphthalate/"Paraplex" G-62/"Santicizer" 409)	10 g. 100
"Naugard" 445	0.5 g.

Piccolastic A-50 is a low molecular weight styrene homopolymer having a softening point of 50°C. and a melt viscosity of 29 centipoises at 190°C., sold by Pennsylvania Industrial Chemical Corp. "Santicizer" 409 is a dibasic acid/glycol-based polyester plasticizer sold by Monsanto Industrial Chemical Co. The resulting data are given in Table II. 105

110

**EXAMPLE 22**

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials:

5	Polymer of Example 7	28 g.
	Piccolastic A-25	25 g.
	Piccolastic A-50	5 g.
	Picotex LC	32 g.
10	Plasticizer Mixture (See Example 21)	10 g.
	"Naugard" 445	0.5 g.

The resulting data are given in Table II.

**EXAMPLE 23**

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials:

15	Polymer of Example 8	15 g.
	"Paraplex" G-62	8 g.
	Piccovar L-30	60 g.
20	Picotex LC	9 g.
	"Elvax" 4260	8 g.
	"Naugard" 445	0.5 g.

The resulting data are given in Table II.

**EXAMPLE 24**

25 Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials:

30	Polymer of Example 9	30 g.
	Picotex 75	40 g.
	Piccovar L-30	25 g.
	"Elvax" 4260	5 g.
	"Naugard" 445	0.5 g.

The resulting data are given in Table II. This composition gave excellent pressure sensitive properties with very high tack and good high temperature bond strength.

**EXAMPLE 25**

Following the procedure of Example 17 a pressure sensitive adhesive blend was prepared by blending the following materials:

40	Polymer of Example 10	25 g.
	Piccolastic A-25	26 g.
	Picotex LC	29 g.
45	Plasticizer Mixture (See Example 21)	10 g.
	Foral 85	10 g.
	"Naugard" 445	0.5 g.

Foral 85 is a highly stabilized ester resin having a ring and ball softening point of about 85°C. sold by Hercules, Inc. The resulting data are given in Table II.

**EXAMPLE 26**

Following the procedure of Example 17 a

pressure sensitive adhesive blend is prepared by blending the following materials:

Polymer of Example 11	25 g.
Piccolastic A-25	28 g.
Picotex LC	27 g.
Plasticizer Mixture (See Example 21)	10 g. 60
Foral 85	10 g.
"Naugard" 445	0.5 g.

The resulting data are given in Table II.

**EXAMPLE 27**

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials:

Polymer of Example 12	28 g.
Piccolastic A-25	25 g.
Piccolastic A-50	5 g. 70
Picotex LC	32 g.
Plasticizer Mixture (See Example 21)	10 g.
"Naugard" 445	0.5 g.

The resulting data are given in Table II.

**EXAMPLE 28**

Following the procedure of Example 17 a pressure sensitive adhesive blend was prepared by blending the following materials:

Polymer of Example 13	28 g. 80
"Picolastic" A-25	25 g.
"Picolastic" A-50	5 g.
Picotex LC	32 g.
Plasticizer Mixture (See Example 21)	10 g. 85
"Naugard" 445	0.5 g.

The resulting data are given in Table II.

**EXAMPLE 29**

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials:

Polymer of Example 14	25 g.
"Paraplex" G-62	10 g.
Piccovar L-30	25 g.
Picotex LC	25 g. 95
"Elvax" 4260	5 g.
"Santicizer" 1 H	10 g.
"Naugard" 445	0.5 g.

"Santicizer" 1 H is N-cyclohexyl-p-toluene sulfonamide sold by Monsanto Industrial Chemical Co. The resulting data are given in Table II.

**EXAMPLE 30**

Following the procedure of Example 17 a

pressure sensitive adhesive blend is prepared by blending the following materials:

	Polymer of Example 15	30 g.
	Nevex 110	25 g.
5	Piccovar L-30	43 g.
	"Santicizer" 3	2 g.
	"Naugard" 445	0.5 g.

10 Nevex 110 is a polyindene petroleum resin sold by Neville Chemical Co. "Santicizer" 3 is N-ethyl-p-toluene sulfonamide sold by Monsanto Industrial Chemical Co. The resulting data are given in Table II. This blend exhibited particular resistance to high temperature shear testing as well as possessing a good overall balance of pressure sensitive properties.

#### EXAMPLE 31

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials:

20	Polymer of Example 15	40 g.
	Neolyn 20	10 g.
	Santicizer 1 H	20 g.
	Nevex 110	25 g.
	Picotex 75	5 g.
25	"Ethyl" 330	0.5 g.

20 Neolyn 20 is a rosin based alkyd resin sold by Hercules, Inc. "Ethyl" 330 is an antioxidant sold by Ethyl Corp. The resulting data are given in Table II.

#### EXAMPLE 32

Following the procedure of Example 17 a pressure sensitive adhesive blend is prepared by blending the following materials:

	Polymer of Example 16	30 g.
	Piccovar L-30	45 g.
	Nevex 110	23 g.
	"Santicizer" 3	2 g.

The resulting data are given in Table II.

#### EXAMPLE 33

Following the procedure of Example 17 a pressure sensitive blend is prepared by blending the following materials:

	Polymer of Example 1	25 g.
	Piccolastic A-5	24 g.
	Piccolastic A-75	18.5 g.
	Picotex LC	20 g.
	"Elvax" 40	4.5 g.
	Plasticizer Mixture (10.0 parts/ 16.5 parts/9.0 parts diisoctyl phthalate/"Paraplex" G-62/"Santicizer" 409)	50
	"Naugard" 445	8.0 g.
	"Ethyl" 330	0.5 g.

The resulting data are given in Table II.

The words "Gilsomite", "Uvitex", "Timopal", "Instron", "Naugard", "Aroclor", "Elvax", "Mylar", "Paraplex", "Santicizer" and "Ethyl" are Registered Trade Marks.

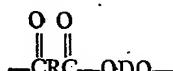
TABLE II  
Pressure Sensitive Properties

60	Blend of Example	Polymer of Example	PSTC-1, lb./in.	PSTC-5, lb./in.	PSTC-6, in.	PSTC-7, hrs.	PSTC-7 (70°C), min.	Polyken Tack, g.
	17 (Control)	2	3.5	—	>12	—	—	—
65	18 (Control)	3	2.0	1.3	4.5	—	—	227
	19	4	0.5	0	>12	—	—	0
	20	5	4.1	3.7	7	300+	13	952
	21	6	1.9	2.0	>12	—	—	113
	22	7	1.3	1.3	>12	—	—	58
	23	8	1.6	0.9	7.3	0.2	—	136
70	24	9	3.7	4.0	4.5	300+	20	636
	25	10	2.2	1.65	—	—	—	420
	26	11	0.5	0.8	—	—	—	70
	27	12	1.8	0	>12	—	—	49
	28	13	0.8	1.1	>12	—	—	125
75	29	14	1.3	0.7	>12	0	—	138
	30	15	4.2	3.5	5.8	300+	22.0	662
	31	15	4.1	2.6	1.5	300+	185	250
	32	16	3.6	2.5	1.0	—	2.0	540
	33	1	0.4	0	—	—	—	70

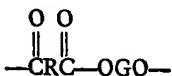
#### 80 WHAT WE CLAIM IS:—

1. A soft thermoplastic segmented copolyester elastomer which has a melt index of less than 30 and a melting point of 90° to 132°C. and consists essentially of 15 to 50 percent by

weight of recurring short chain ester units of 85 the formula:



joined through ester linkages to 50 to 85 percent by weight of long chain ester units of the formula:



- 5 wherein R represents the divalent aromatic groups remaining after removal of the carboxyl groups from a mixture of aromatic dicarboxylic acids (as hereinbefore defined) of molecular weight less than 350 and containing 55
- 10 to 95 percent by weight of terephthalic acid, D represents the divalent group remaining after removal of the hydroxyl groups from butanediol, and G represents the divalent group remaining after removal of the terminal hydroxyl
- 15 groups from a polytetramethylene ether glycol having an average molecular weight of 1500 to 3500.
- 2. An elastomer according to claim 1, wherein in the admixture of aromatic dicarboxylic acids is a mixture of terephthalic acid and isophthalic acid.
- 3. An elastomer according to claim 2, wherein in the mixture contains 60 to 75 percent by weight of terephthalic acid.
- 25 4. An elastomer according to any one of the preceding claims wherein the polytetramethylene ether glycol has a molecular weight of 2000 to 3000.
- 5. An elastomer according to any one of the
- 30 preceding claims which comprises from 15 to less than 30 percent by weight of the short chain ester units and more than 70 to 85 percent by weight of the long chain ester units.
- 35 6. An elastomer according to claim 1 substantially as described in any one of Examples 1 and 4 to 16.

- 7. A thermoplastic composition which comprises, based on the total thermoplastic components, (A) 1 to 99 percent by weight of a thermoplastic segmented copolyester elastomer as claimed in any one of the preceding claims and (B) 1 to 99 percent by weight of a low molecular weight thermoplastic resin which forms compatible mixtures with the segmented copolyester, is thermally stable at 150°C., and has a melt viscosity of less than 10,000 centipoises at 200°C. 40
- 8. A composition according to claim 7, wherein the low molecular weight thermoplastic resin (B) is a hydrocarbon resin, bituminous asphalt, coal tar pitch, rosin, rosin based alkyd resin, phenolic resin, chlorinated aliphatic hydrocarbon wax or chlorinated polynuclear aromatic hydrocarbon or a mixture of at least two such resins. 45
- 9. A composition according to claim 7 or 8 which comprises 5 to 95 percent by weight of (A) and 95 to 5 percent by weight of (B). 50
- 10. A composition according to claim 9 which comprises 20 to 60 percent by weight of (A) and 80 to 40 percent by weight of (B). 60
- 11. A composition according to claim 7 substantially as described in any one of Examples 19 to 33.
- 12. A method of bonding which comprises the step of applying a pressure sensitive adhesive layer to a substrate, wherein the pressure sensitive adhesive is a thermoplastic composition as claimed in any one of claims 7 to 11. 65

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